

Date: Thursday, 11/9/2006 4:37:48 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BUSHING	
Job Number	: 29393		Part Number	: D28061	
Estimate Number	: 10517		Drawing Number	: D2806 REV A	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 11/9/2006 S.O. No. : N/A		Drawing Revision	: A	
Prsh Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 11/24/2006 Qty: 42	
Previous Run	: 28162		Um:	Each	
Written By	: <u>KJ</u> 06/11/10				
Checked & Approved By					
Comment	: Est:B 06.03.11 Part now turned KJ/JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6H1000	6061-T6 1" HexBar	
<p>Comment: Qty.: 0.0962 f(s)/Unit Total : 3.8472 f(s)            6061-T6 Hex Bar 1.0"            Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11) 1.00" Hex Bar <u>102605</u>            (M6061T6H1.000) Batch: <u>100720</u> <u>8F 06/11/13</u> 42</p>			
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
<p>Comment: HARDINGE CNC LATHE SMALL            1-Turn as per Folio FA105 and Dwg D2806            2-Tumble <u>8F 06/11/13</u> 42</p>			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
<p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>9/8 06/11/13</u> 42</p>			
4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
<p>Comment: CONVENTIONAL MILLING MACHINE            Drill as per Dwg D2806 <u>9/8 06/11/13</u> 42</p>			
5.0	QC8	SECOND CHECK	
<p>Comment: SECOND CHECK <u>JL 06/11/13</u></p>			

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/11/15  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BUSHING

Job Number: 29393

Part Number: D28061

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 
		<i>jl 06/11/14 x 42</i>
Comment:	HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1	
7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
		<i>7/16/11/15 (42)</i>
Comment:	INSPECT ALODINE	
8.0	PACKAGING 1	PACKAGING RESOURCE #1 
		<i>7/16/11/15 (42)</i>
Comment:	PACKAGING RESOURCE #1 Identify and Stock Location: <i>57387</i>	
9.0	QC21	FINAL INSPECTION/W/O RELEASE 
		<i>7/16/11/15 (42)</i>
Comment:	FINAL INSPECTION/W/O RELEASE	<i>7/16/11/15 (42)</i>

Job Completion



*7/16/11/15*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	29393
Description: Bushing	Part Number:	D2806-1
Inspection Dwg: D2806	Rev: A	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by: <u>JF/Pml</u>	Audited by: <u>JL</u>	Prototype Approval:	N/A
Date: <u>06/11/13</u>	Date: <u>06/11/13</u>		Date: N/A

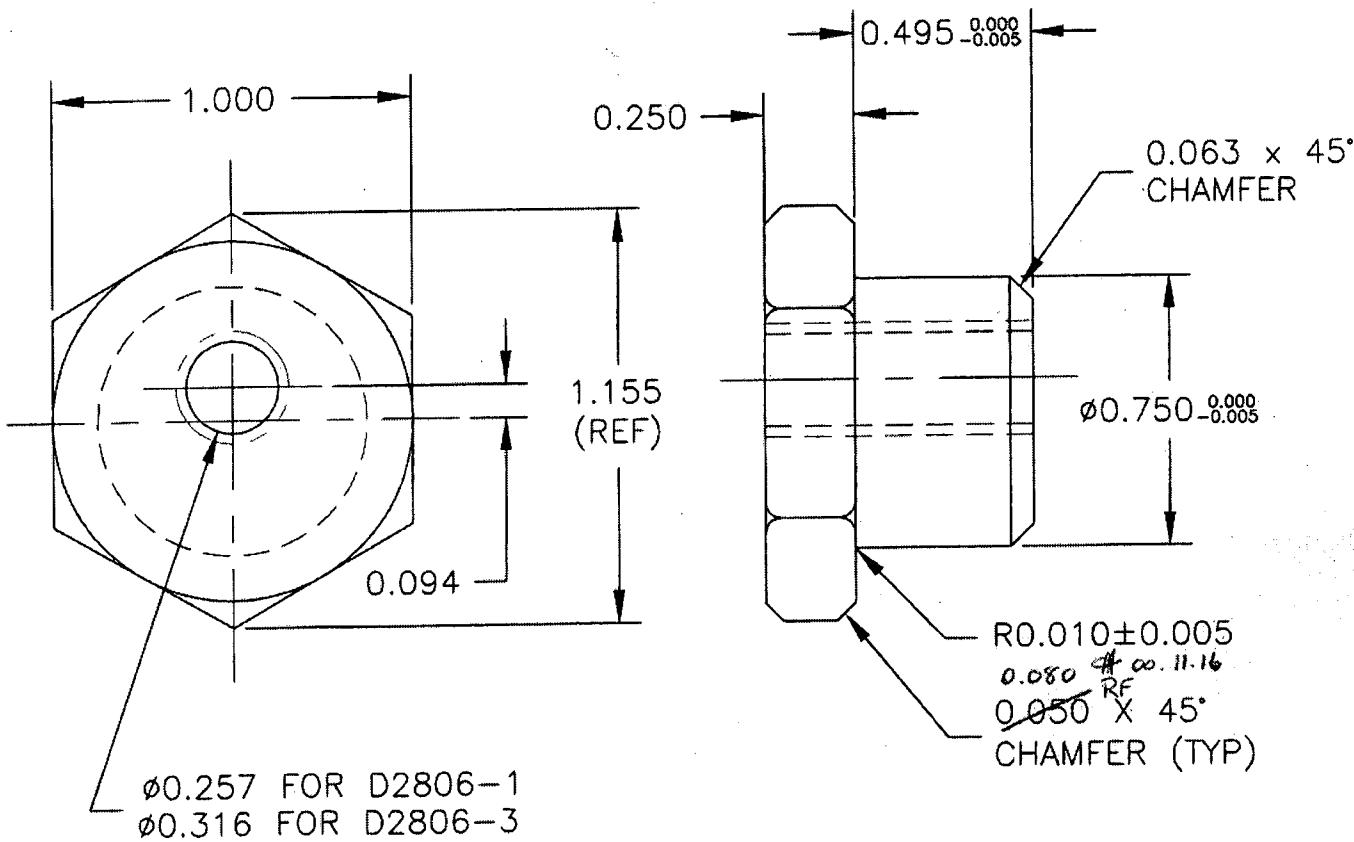
Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue	KJ/RF 	



GCOPY  
DRAFT

DESIGN	DRAWN BY	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
CP		D2806	SHEET 1 OF 1
DATE		TITLE	SCALE
00.11.08		BUSHING	2:1
A	00.11.08	NEW ISSUE	

RELEASED  
00.11.13



D2806-1 (DRILL  $\emptyset 0.257$  HOLE)  
D2806-3 (DRILL  $\emptyset 0.316$  HOLE)

MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) OR (QQ-A-225/8)  
 FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
 BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020  
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 29393